

ASAP

Dart Aerospace Ltd.

Date: Friday, 04/04/2008 9:46:53 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INNER AFT SADDLE  
 Job Number : 38368  
 Estimate Number : 11082  
 P.O. Number :  
 This Issue : 04/04/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D5957  
 Drawing Number : D5957 REVB  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 23/04/2008 Qty: 20 / 16 Um: Each  
 First Issue : 04/04/2008 Type : MACHINED PARTS  
 Previous Run : 36462  
 Written By :  
 Checked & Approved By : JLO 08.04.4  
 Comment : Est Rev:E Re-Format 05-11-29 JLM  
 Est Rev:F ecn826 06.12.06 ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: 31389

JLP 08/04/18 (21)

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

JLP 08/04/18 / 28 08/04/19 (22)

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

28 08/04/19 (20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/04/21

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-22 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: N/A Fault Category: Prod/Eng Coding NCR ☒ Yes ☐ No DQA: LD Date: 08/04/21  
 QA: N/C Closed: D Date: 08/04/21

NCR: <u>38368</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/21</u>	<u>2.0</u>	<u>ERROR IN program for roughen HTIS IT was program too deep. New Program.</u>	<u>[Signature]</u> <u>08/04/21</u>	<u>Scrap and Destroy and Replace B# <u>31389</u></u>	<u>SP</u> <u>08/04/21</u>	<u>[Signature]</u> <u>08/04/21</u>	<u>[Signature]</u> <u>08/04/21</u>	<u>[Signature]</u> <u>08/04/21</u>
				<u>Fix Program error.</u>	<u>[Signature]</u> <u>08/04/21</u>	<u>[Signature]</u> <u>08/04/21</u>		<u>[Signature]</u> <u>08/04/21</u>

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:46:53 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 38368

Part Number: D5957

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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*in 107550*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR. 08-04-23*

*30 MIN*  
22/04/2008  
S.094 15.49  
#1 319.8 F  
#3 38368 F  
#5 5957 F

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08/04/23*

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57421*

*08/04/23 (20)*

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*08/04/24*

Job Completion



*UMF 08-04-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38368
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442	.442	.442	.442		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.002	7.002	7.002	7.002		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.581	4.581	4.581	4.581		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.501	.501	.501	.501		
M	0.490	0.510		.505	.505	.505	.505		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.003	8.005	8.004	8.004		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.311	.312	.312	.312		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.510	.505	.505	.505		
T	1.625	1.645		1.637	1.637	1.637	1.637		
U	2.000	2.020		2.007	2.007	2.007	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>S.F.</u>
Date: <u>08/04/19</u>

Audited by: <u>J.L.</u>
Date: <u>08/04/21</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	38368
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957		<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5x	6x	7x	8x	By	Date
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.051	3.051	3.051	3.051		
J	4.575	4.585		4.581	4.581	4.581	4.581		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.501	.501	.501	.501		
M	0.490	0.510		.503	.504	.504	.504		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.002	8.002	8.002	8.002		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.505	.505	.505	.505		
T	1.625	1.645		1.635	1.635	1.635	1.635		
U	2.000	2.020		2.002	2.002	2.002	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ST
Date:	08/04/19

Audited by:	JL
Date:	08/04/21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38368
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.442	.442	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.051	3.051	3.051	3.051		
J	4.575	4.585		4.581	4.581	4.581	4.581		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.502	.500	.500	.500		
M	0.490	0.510		.505	.505	.506	.506		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.004	8.005	8.002	8.004		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.500	.505	.510	.501		
T	1.625	1.645		1.638	1.638	1.638	1.638		
U	2.000	2.020		2.000	2.022	2.002	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: RF
Date: 08/04/20

Audited by: J.L.
Date: 08/04/21

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C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38368
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	15	16		
A	0.438	0.443		.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.051	3.051	3.051	3.051		
J	4.575	4.585		4.581	4.581	4.581	4.581		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.505	.501	.501	.501		
M	0.490	0.510		.505	.505	.505	.504		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.005	8.006	8.006	8.006		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.765	.765	.765	.765		
S	0.490	0.510		.500	.500	.500	.500		
T	1.625	1.645		1.638	1.638	1.638	1.638		
U	2.000	2.020		2.000	2.004	2.004	2.004		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JF
Date: 08/04/20

Audited by: J.L
Date: 08/04/21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Inner Aft Saddle</b>		<b>Part Number: D5957</b>	
<b>Inspection Dwg: D5957</b>		<b>Rev: B</b>	
		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	142	178	204	By	Date
A	0.438	0.443		.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	<del>5.745</del>	<del>5.755</del>		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.526	1.526	1.526	1.526		
I	3.048	3.058		3.051	3.051	3.051	3.051		
J	4.575	4.585		4.581	4.581	4.581	4.581		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.501	.501	.501	.501		
M	0.490	0.510		.505	.505	.505	.504		
N	1.865	1.885		1.875	1.875	1.875	1.875		
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P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.312	.312	.312	.312		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.502	.502	.502	.502		
T	1.625	1.645		1.638	1.638	1.638	1.638		
U	2.000	2.020		2.004	2.004	2.002	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

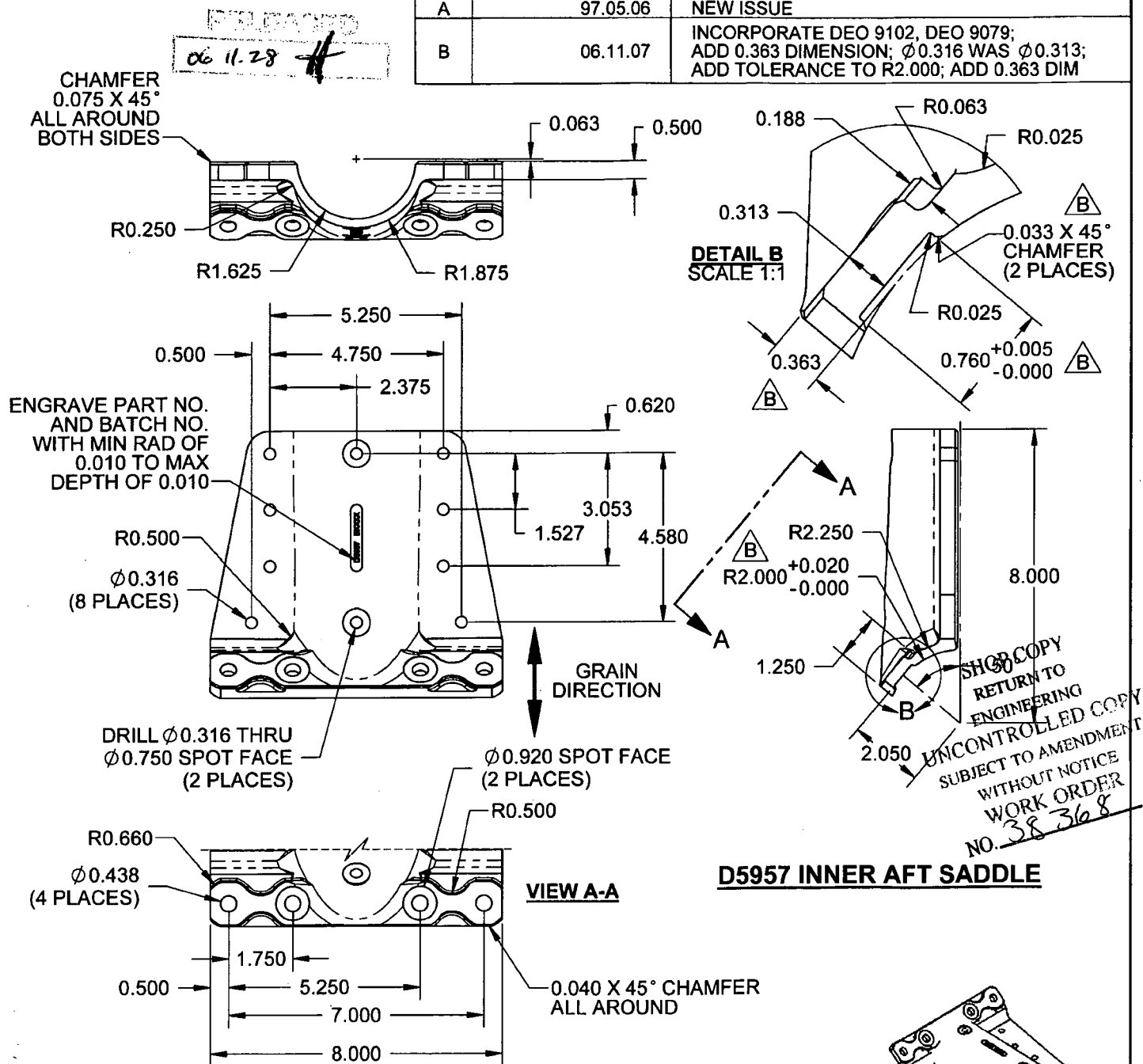
Measured by: <i>845</i>
Date: <i>08/04/21</i>

Audited by: <i>31</i>
Date: <i>08/04/21</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b> SCALE 1:4		
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>	
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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